

5111644



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D6101-001
Job Sheet 182328



Part No: D6101-001

Job Qty: 20 ea

Part Name: Saddle Billet



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/17/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	20 pcs		9/17/18	0.00	0.00	Purchasing		AT 18/09/19
110	Packaging	20 pcs		9/17/18	0.00	0.00	Packaging2		AT 18/09/19
120	QC	20 pcs		9/17/18	0.00	0.00	QC6		AT 18/09/19
130	Packaging	20 pcs		9/17/18	0.00	0.00	Packaging3-2		SB 18/09/20
140	QC21-SA	20 Ea		9/17/18	0.00	0.00	QC21		SEP 26 2018

Part Op 100 - Issue P/O: 040834 a) Description: Aluminum billet b) 6.00" x 6.250" x 2.00" thick c) Tolerance on length
Descriptions: are +0.030"/-0.000" E +/- 0.008" d) Grain direction along 6.00" length e) Material: 7075-T7351 (QQ-A-250/12)

110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D

130 - LOCATION: MAT042

AUG 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001P	7075-T7351 2X6X6.25	20 pcs (1 ea)	100-Purchasing	5111620

Job Allocations

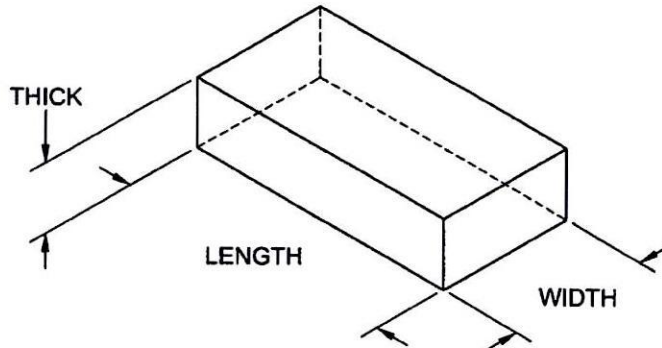
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D6101-001P	20	0	0

Part Specifications

Specifications could not be found.

Plex 8/23/18 6:57 AM dart.lavoie.chantal

SPECIFICATION CONTROL DRAWING



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

B ACCEPTABLE SPECIFICATIONS FOR 7075-T7351 ALUMINUM ARE AMS-QQ-A-250/12, QQ-A-250/12, OR ASTM B209

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length
D6101-015	7075-T7351 (QQ-A-250/12)	9.450	6.250	2.500	Along 9.450 Length
D6101-017	7075-T7351 (QQ-A-250/12)	6.350	6.250	2.250	Along 6.350 Length

RELEASED
09/07/15/W

B	ADDED D6101-015/-017, ADD ASTM B209	RF	09.04.23
A	NEW ISSUE	CP	01.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D6101	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SADDLE BILLET, 7075	NTS
DATE	09.04.23	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040834

Supplier: MEC002-VU
Metaux Castle
P.O. Box 4090 Stn A
Toronto
ON
M5W OE9 Canada

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040834
PO Date: 8/23/18
Due Date: 9/17/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Baker, Diane Phone: dbaker@dartaero.com
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

E-MAILED
AUG 24 2018
Relief

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1 <i>AT</i>	182328	D6101-001P		7075-T7351 2X6X6.25 AS PER DWG D6101 REV. B SIZE: 6.00" X 6.250" X 2.00" THICK GRAIN DIRECTION ALONG 6.00" LENGTH MATERIAL: 7075- T7351 QQ-A-250/12 TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	20 pcs	0 pcs <i>20x</i>	20 pcs <i>AT</i>	\$26.88/pcs <i>18/09/19</i>	\$537.60
2 <i>AT</i>	182329	D6101-013P		Saddle Billet : Various STC's AS PER DWG D6101 REV. B MATERIAL: 7075- T7351 (QQ-A-250/12) SIZE: 10.100" X 8.250" X 2.50" THICK GRAIN DIRECTION ALONG: 10.100" LENGTH TOLERANCE AS PER QUOTE +.030"/-.000"	Firmed	-	9/13/18	10 pcs	0 pcs <i>10x</i>	10 pcs <i>AT</i>	\$73.15/pcs <i>18/09/19</i>	\$731.50
3 <i>AT</i>	182330	D6101-015P		Aluminum Billet : Various STC's As per Dwg.D6101 Rev. B	Firmed	-	9/13/18	10 pcs	0 pcs <i>10x</i>	10 pcs <i>AT</i>	\$52.00/pcs <i>18/09/19</i>	\$520.00
4 <i>AT</i>	182320	D6104-005P		17-4 SS Roundbar 4.00"Od AS PER DWG D6104 REV. B MATERIAL: 17-4 PH AS PER AMS 4643 OR AISI 630	Firmed	-	9/6/17	10 pcs	0 pcs <i>10x</i>	10 pcs <i>18/09/06 AT</i>	\$54.20/pcs	\$542.00



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PURCHASE ORDER PO040834

Items												
Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
				SIZE: 4.00" X 5.10" LONG								
5 /AT	182461	D6101-015P		Aluminum Billet : Various STC's As per Dwg D6101 Rev. B	Firmed	-	9/13/18	10 pcs /	0 pcs 10x	10 pcs	\$52.00/pcs AT 12/02/19	\$520.00
Grand Total:												\$2,851.10

Order Notes

Procurement Quality Clauses

- A005 right of entry
- A012 chemical and physical test report
- A016 personnel qualification
- A017 raw material identification (as applicable)
- A026 certification of material conformance
- A041 quality management system
- A042 dart notification by supplier
- A043 retention of quality documents
- A048 counterfeit parts avoidance, detection, mitigation and disposition program
- A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/24/18 3:22 PM dart.baker.diane

Handwritten initials and signature: C.Y. and a signature.

**Castle Metals®**

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 1 of 2

Shipment No:3704384

Ship From: A. M. CASTLE & CO. 2150 ARGENTIA ROAD MISSISSAUGA, ON L5N 2K7 CAN		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 18-SEP-18	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier MANITOULIN		BOL No 3704384-2	

Shipment Details	Final Destination Branch - TOR
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Order No 5239060	Line No 1	Item No 752237.MO	Description 2.0000.PL.7075.T7351.ALUMINUM.USI.48.5000.144.5000 CUT RECTANGLE TO 6.25 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) X 6 IN (+ .0310/- .0000 IN (GRAIN TO RUN ALONG 6")) - ALUMINUM PLATE SAW SPECIFICATIONS: AMS-QQ-A-250/12	
Purchase Order No 40834		Part Number YOUR ITEM NUMBER: D6101-001	Ordered Qty 20.00 PCS	Invoice Qty 20.00 PCS

Details	ALL PAPERWORK MUST FOLLOW ORDER / CUSTOMER MUST RECEIVE AT TIME OF DELIVERY ALL MATERIAL MUST HAVE IDENTIFYING MARKINGS EX:HEAT #S Email P/s and certs to: clavoie@dartaero.com END USER: DART AEROSPACE END USE: COMMERCIAL AIRCRAFT PARTS
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Delivery No. 122128131	Mill/Source CONSTELLIUM ROLLED PRODUCTS	Heat Number 	Mech Id	PCS 20	Width (IN)	Length (IN)	Shipped Qty(LBS) 154.8319
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We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Date Printed: 18-SEP-2018 03:39:01 PM

26647584



Castle Metals®

A. M. Castle & Co.

PACKING SLIP/
CERTIFICATE OF CONFORMANCE

Page 2 of 2

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

SEP 18 2018

SUE KALOUS





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

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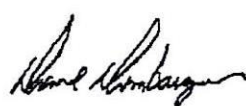
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A M CASTLE & CO.
14001 ORANGE AVE.
PARAMOUNT CA
90723
US

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A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE		110686621		4776		INCLUSION		Serial:20180806-0110686621		Pg 1of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 470678						Constellium ORDER NO. 248366					
ALLOY 7075		CLAD		TEMPER T7351		GAUGE 2.00000 in 50.80 mm		WIDTH 48.50000 in 1,232 mm		LENGTH 144.50000 in 3,670 mm	
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS 4078J											
PART NUMBER 752237				B/L NUMBER 103955				DATE SHIPPED 08/06/2018			
WT. SHIPPED 4275.000 LB				NO. OF PIECES 000003				GOVT. CONTRACT NO.			
										 Dave Dunbarger - Laboratory Manager	

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

ASTM B594 REV 13 2013 100% SONIC W/ 0.12" DEADZONE Class A
AMS QQ-A-250/12A
AMS-STD-2154C 2017 TYPE1 CLASS A 100% SONIC MINUS DEADZONE
ASTM B209-14
BSS-7055B 2013 CLASS A 100% SONIC TESTED MINUS DEADZONE
CMMP025 REV V
CSTI006 REV E 2011 CLASS A 100% SONIC MINUS DEADZONE
DPS 4.713 REV AK 2012 CLASS A 100% SONIC MINUS DEADZONE
GAMPS 9101 REV B 2006 CLASS A 100% SONIC MINUS DEADZONE
MMS 159T
PS 21211P 2010 CLASS A 100% SONIC MINUS DEADZONE

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001848469	1,425.000	646.369	9425809	01		
1001848469	1,425.000	646.369	9425809	02		
1001848469	1,425.000	646.369	9425809	03		

Lot: 9425809 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	74.4	74.9	63.0	64.1	11.5	12.0	





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
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T
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A M CASTLE & CO.
14001 ORANGE AVE
PARAMOUNT CA
90723
US

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D

T
O

A M CASTLE
1420 KENSINGTON ROAD, SUITE 220
OAK BROOK IL
60523
US

A M CASTLE		110686621		4776		INCLUSION		Serial:20180806-0110686621		Pg 2of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 470678						Constellium ORDER NO. 248366					
ALLOY 7075		CLAD		TEMPER T7351		GAUGE 2.00000 in 50.80 mm		WIDTH 48.50000 in 1,232 mm		LENGTH 144.50000 in 3,670 mm	
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS 4078J											
PART NUMBER 752237				B/L NUMBER 103955				DATE SHIPPED 08/06/2018			
WT. SHIPPED 4275.000 LB				NO. OF PIECES 000003				GOVT. CONTRACT NO.			
 Dave Dunbarger - Laboratory Manager											
Tensile - Room Temperature (SI)											
		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report			
Direction	Tests	Min	Max	Min	Max	Min	Max				
LT	02	513	516	434	442	11.5	12.0				
Conductivity % IACS MIN 40.0 MAX 40.0 % MS/M MIN 23.2 MAX 23.2											
Chemistry (Actual)											
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR		
Core	0.08	0.17	1.46	0.03	2.62	0.21	5.60	0.03	0.01		
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER											
All material contained in this lot was cast and manufactured in the USA											
QUALITY TEXTS: AMC CA-15413A R 9											
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557 DUNS Number: 090570149; CAGE Code: 1YW19 Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"											
P-860-155D REVISED: 01 2018											

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D6101-001
 DATE: 18/09/19

PO / BATCH NO.: P0040834/S111644

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 20
 QUANTITY INSPECTED: 20
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 2.000"
 THICKNESS RECEIVED: 2.000"
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS QQ-A-250/12
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT: 9425809
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: <u>AT</u> DATE: <u>18/09/19</u>	SIGNED OFF BY: _____ DATE: _____

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in